

Split

Work Order ID 64311-1

Thursday, December 02, 2010 8:57:01 AM

Page 1

Item ID: D2153

Revision ID:

Item Name: Door Prop

Start Date: 12/2/2010

Required Date: 12/9/2010

Reference:

Accept

Setup Start

Stop

Cust Item ID:

Customer:

Approvals:

Process Plan:

QC:

Date: 10-12-2

Tooling:

Date:

Run Start

Stop

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D2153

Rev A1

100



Purchasing

Purchasing

PURCHASING

0.00

Memo

0.00

Issue P/O: 13069 ☐ Gas Spring P/N: SL13-10 (10lb) ☐ Possible
supplier: Spring Lift Corporation ☐ **Note: Do not ship by air**** ☐ Allow an
extra 7 to 10 business days for shipping** ☐ Material release note is required

CL 10/12/06 (36)

110



Packaging

Packaging

Receive & Inspect for Damage & Mat'l Certs

0.00

Memo

0.00

Ensure Material Release Note is attached

11/12/13 (36)

120



QC

Quality Control

QC6- Inspect dimensions to drawing

0.00

Memo

0.00

Inspect Test Spring is 10lb

8/12/13

count
(x36)

Work Order ID 64311

Thursday, December 02, 2010 8:57:01 AM

Page 2

Item ID: D2153

Revision ID:

Item Name: Door Prop

Start Date: 12/2/2010 Start Qty: 20.00

Required Date: 12/9/2010 Req'd Qty: 20.00

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130



Small Fab

Small Fab

0.00

Memo

0.00

1- Assemble as per Dwg D2153; 2- Remove Spring Lift name and address with Acetone, leave only warning: "DO NOT OPEN HIGH PRESSURE"

E. [Signature]
11/01/04
36
①

140



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

*Sulaboy**(+1)*

[Signature]
235
①

150



Packaging

Packaging

Identify as per dwg & Stock Location: *22*

0.00

Memo

0.00

[Signature]
11/10/10
①

Work Order ID 64311

Thursday, December 02, 2010 8:57:01 AM



Page 3

Item ID: D2153

Accept



Setup Start



Revision ID:

Stop



Item Name: Door Prop

Start Date: 12/2/2010 Start Qty: 20.00



Cust Item ID:

Required Date: 12/9/2010 Req'd Qty: 20.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC21 - Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

CK 11/01/05

BS 11-01-5
(1)

Picklist Print

Thursday, December 02, 2010 8:57:06 AM

Page 1

Work Order ID: 64311

Parent Item: D2153

Parent Item Name: Door Prop



Start Date: 12/2/2010

Required Date: 12/9/2010

Start Qty: 20.00

Required Qty: 20.00

Comments: IPP: E 02.07.08 Re-format KJ/RF

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

SL69-BS



Ball Stud

Purchased

No

100

Each

71.0000

2

40

Location

ST397

115033

Loc Qty

71

71

Loc Code

AN960JD516

NAS1149D0563J

Purchased

No

130

Each

34.0000

2

40



Washer

LD M114742

Location

ST

103694

107534

109287

Loc Qty

34

18

12

4

Loc Code

D2153P



Door Prop

Purchased

No

130

Each

0.0000

1

20

64311

D3015-3



Locknut

Manufactured

No

130

Each

55.0000

2

40

Location

ST033

43758

56701

60287

Loc Qty

55

26

3

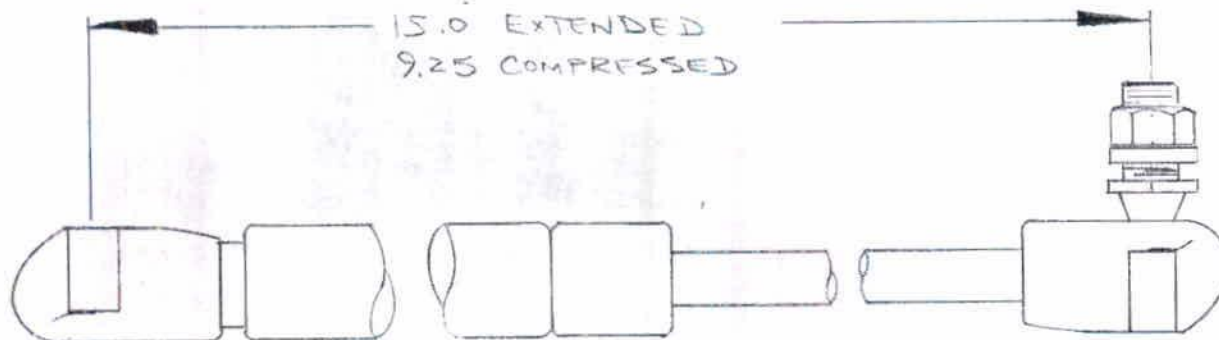
26

Loc Code

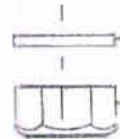
EP 10/12/14
71 M116475 (W)
EP 10/12/14
EP 10/12/14
B64511 (W)
21
17

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 64311

BS 10-12-2



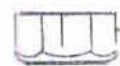
SL-13-10 SPRING (SPRING LIFT CORP)



SL69-BS STUD (SPRING LIFT CORP)



AN 960-516 WASHER



5/16-18 UNC SELF LOCKING NUT

D3015-3 A1



RELEASED
96/07/16

D2153

REVISION DRAWN APPROVED DESCRIPTION OF CHANGE		THIS DRAWING IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMPILED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT THE PERMISSION OF DART AERO.		RIVET CODE SHALL BE PER NAS 523 BASIC CODE D=DOUBLE C=COUNTDOWN BASIC CODES B=MS20470AD BB=MS20476AD		PART NO. CONTRACT NO. DRAWN DESIGN CHECKED DATE 27.2.72		MATERIAL DART DART AERO ACCESSORIES INC. VANCOUVER CANADA		SPEC. VENDOR DART AERO ACCESSORIES INC. VANCOUVER CANADA			
REQUIREMENTS - UNLESS OTHERWISE SPECIFIED GENERAL 1. DIMENSIONS ARE IN INCHES 2. SURFACE ROUGHNESS 125 3. REMOVE SHARP EDGES .015 MAX 4. THREADS PER INCH - 5 - 3342 5. HOLES PER AND 10387		LIMITS 1. TOLERANCES - .005 & .003 2. ANGLES 3. PARALLELISM 4. ECCENTRICITY 5. SYMMETRY ABOUT ALL MAT. CENTRE LINES DMS		LENGTH DASHING W=SPOTFILLED		TITLE GAS SPRING ASSEMBLY		CODE D2153		SCALE 1:1		SHEET 1 OF 1	

REPORT ALL DISCREPANCIES - DO NOT SCALE



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID PO13069

Purchase Order Date 12/06/10

PO Print Date 12/06/10

Page Number 1 of 1

Order From :

VU-ATT001

ATTWOOD
1016 NORTH MONROE STREET
LOWELL, MI 49331
US

Contact Name
Vendor Phone 616 897 2370
Vendor Fax 616 897 8358
Vendor Account Nbr

Buyer Chantal Lavoie
Requisition Nbr
Tax Resale Nbr 10127-2607
Terms Net 30
Currency USD
FOB Destination-Collect

Ship To : DART AEROSPACE LTD 1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

collected

Line Nbr	Reference Revision ID Vendor Part Number	Description/ Mfg ID	Req Date/ Taxable	Req Qty/ Unit of Measure	Ship Method	Unit Price	Extended Price
1	D2153P	Door Prop	12/13/10 Yes	36.00 Each	FedEx PI collect	\$4.1900	\$150.84

Special Inst: AS PER DWG D2153 REV. A
B64311
ATTWOOD P/N: SL13-10

PO Total: \$150.84

CERTIFICATE OF CONFORMITY
REQUIRED

Change Nbr: 1

Change Date: 12/06/10

h *CL*
No substitution or deviation without
consent.
Certificate of Conformity or Material
Certification required when applicable



genuine ingenuity

TELEPHONE: 616-897-2290

MotorGuide
NEVER STOP

TRUST: 62590 MST: 10356-00

COLLECT

131793240

BILL TO: DART AERO LTD.
REG: 12/07/10

PRO NO: 778104409
SHIP VIA: FEDEX GROUND
BOL#: 00226970002260232

FREIGHT: _____

ATTWOOD / MOTORGUIDE

1016 NORTH MONROE
LOWELL

MT 49331-02360

DART AERO LTD.
1270 ABERDEEN STREET

HAWKESBURY

DN

K6A 1K7

CRIS:

1

PC#:

13069

ACT:

12

DATE: 12/06/10

SPUR: 8

LABEL NO:
5402240821

ROUTING GUIDE INFO --

SHIPPED--

QTY

LOCATN

DN

PART# / UPC

DESCRIPTION / SKG

ORD

LN QTY RES

1 36

ZC9211

EA SL13-10-1

GS SPRNG 15" EXTC 10# BL

1

36 12

8012/13